

Date: Thursday, 9/20/2007 3:29:10 PM  
User: Kim Johnson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
Job Number : 34749  
Estimate Number : 10531  
P.O. Number : N/A Part Number : D2572  
This Issue : 9/20/2007 S.O. No. : N/A Drawing Number : D2572 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
Previous Run : 34368 Material : N/A  
Written By : Due Date : 10/1/2007 Qty: 6 Um: Each  
Checked & Approved By :  
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: B31388

2.5 07/10/17

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 2.5 Double check by: ml  
34749

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

2.5 07/10/17

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

2.5 07.10.23

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2.5 07.10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-10-23		split c/d	<i>[Signature]</i>		4		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number: 34749

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/10/23

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/10/23

(6x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105008

BL

07-10-24

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/24 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/10/24 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

(6)

Job Completion



U 07.10.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34749</b>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	.441	.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.499	3.499	3.498	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.749		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.500	.500	.502	.507		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.377	.377	.377	.375		
I	0.490	0.510		.500	.501	.510	.501		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.568	.569	.578	.568		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.500		
N	2.495	2.505		2.500	2.500	2.501	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.124	.122	.122	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.250		
S	0.115	0.135		.134	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.967	2.962		
V	0.230	0.250		.240	.240	.235	.240		
W	0.115	0.135		.130	.130	.135	.130		
X	0.307	0.312		.312	.312	.312	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.383	1.386	1.397	1.390		
AF	0.115	0.135		.135	.135	.131	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.001	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>S.F.</i>
Date:	07/10/18

Audited by:	<i>J.L.</i>
Date:	07/10/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34749
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443	DT8682	.441	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.005				
F	0.490	0.510		.500	.502				
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.505	.504	.504			
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570			
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.254	.254			
S	0.115	0.135		.125	.125	.125			
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.240	.240	.240			
W	0.115	0.135		.130	.130	.130			
X	0.307	0.312		.310	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.362				
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.633				
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.388	1.388	1.388			
AF	0.115	0.135		.125	.125	.125			
AG	0.240	0.280		.250	.250	.250			
AH	0.240	0.260		.250	.250	.250			
AI	2.000	2.020		2.003	2.002	2.001			
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by: <i>JS</i>
Date: 07/10/21

Audited by: <i>JS</i>
Date: 07/10/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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P	0.115	0.135							
Q	0.115	0.135							
R	0.240	0.260							
S	0.115	0.135							
T	0.178	0.198							
U	2.940	2.980							
V	0.230	0.250							
W	0.115	0.135							
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372							
AA	0.470	0.530							
AB	0.615	0.635							
AC	0.053	0.073							
AD	0.240	0.260							
AE	1.375	1.395							
AF	0.115	0.135							
AG	0.240	0.280							
AH	0.240	0.260							
AI	2.000	2.020							
AJ	0.023	0.043							
Accept/Reject									

Measured by: J.D.
Date: 02/10/22

Audited by:
Date:

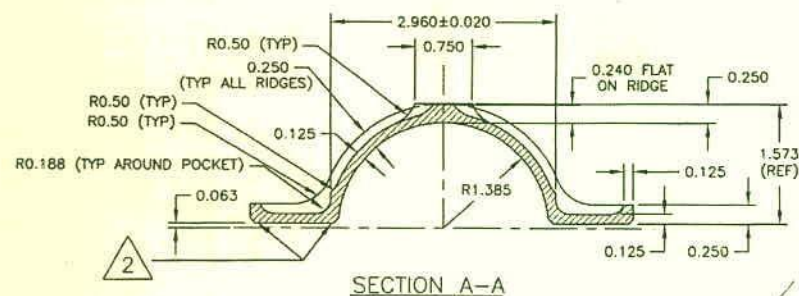
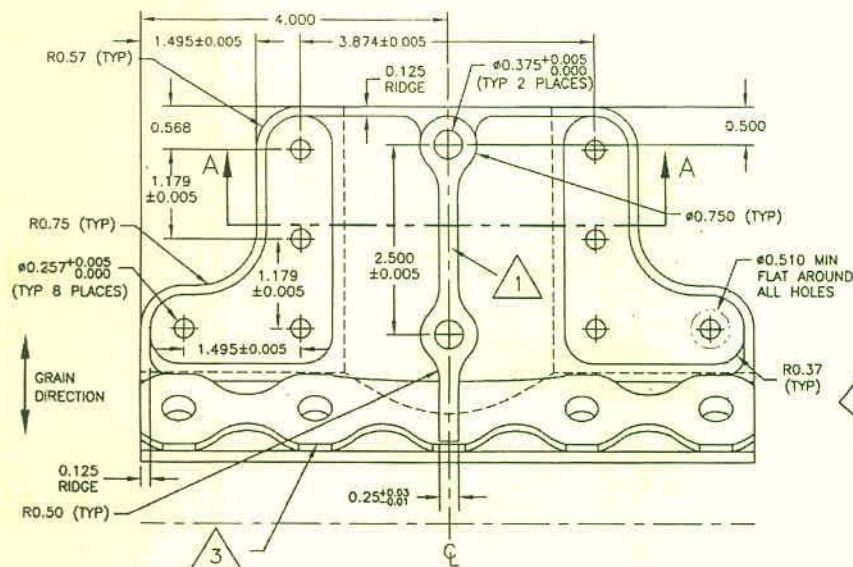
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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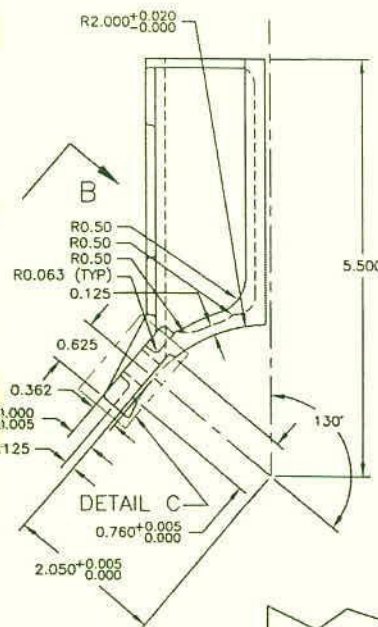


RELEASED

05.12.06



SECTION A-A



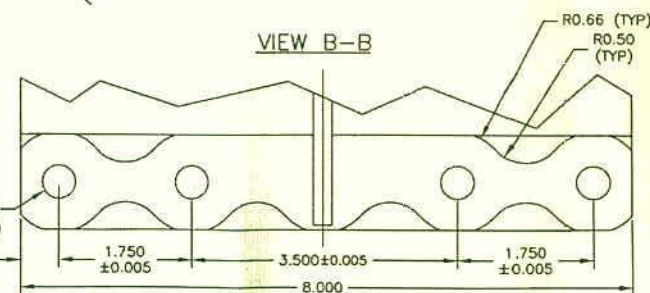
DETAIL C

## NOTES

MATERIAL: 7075-T7351 (00-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
3 CHAMFER 0.063 x 45° ALL AROUND  
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES: TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEQ 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		INNER FWD SADDLE

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DART AEROSPACE LTD.

**DART**DART AEROSPACE LTD.  
WARRICKBURY, OXFORD, ENGLAND

REV. E

SHEET 1 OF 1

SCALE

2:3

DETAIL C  
SCALE 2:1

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WITHOUT NOTICE  
WORK ORDER  
NO. 34749

